

Work Order ID 146082

Thursday, July 07, 2016 1:03:20 PM

146082

Page 1

Item ID: D4151-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lower Hardpoint Plate

Stop ***NS2***

Start Date: 5/3/2016 Start Qty: 30.00

Required Date: 5/5/2016 Req'd Qty: 30.00

~~*30*~~
~~*30*~~

43 *JA*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4151

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut as per dwg D4151

Prog Rev: C

Dwg Rev: C

Deburr as required

0.25

43

DAS

45 2016-8-4
9-89

Pho →

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.05

43

DAS

45 2016-8-4
9-89

DQA:

Date: 16.08.29



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date: 16.08.10

Work Order update only ☐

Work Order: 146082	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
Part No. D4151-1		Skid-tube ☐	Crosstube ☐	Water Jet ☒	Engineering ☐
NCR No. 16-5966		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
		Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	16.08.05	100	all	Holes in part where Found to be inconsistent, varying dimension and some with tapered P.C. operator, setup.	DAS 9 9-89 16.08.05	Rework holes as per drawing using drill bit Debur Debur Fill in new F.A.I.	PR 16/08/08	DAS 16 9-89 16/08/08	DAS 16 9-89 16/08/08
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☒ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Item ID: D4151-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Hardpoint Plate

Start Date: 5/3/2016 Start Qty: 30.00

30

Cust Item ID:

Required Date: 5/5/2016 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.10				<u>(43)</u> Count: 100% inspect			DAS 16 9-89 16/08/16
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <u>ST087</u> Memo	0.00 0.05				<u>(48)</u>	<u>Pc</u>		AUG 09 2016
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.50							16/8/19 <u>[Signature]</u> SOL AUG 09 2016

Picklist Print

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Work Order ID: 146082

146082

Parent Item: D4151-1

D4151-1

Parent Item Name: Lower Hardpoint Plate

Start Date: 5/3/2016

Required Date: 5/5/2016

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
11.01.21 as per dwg revC DD verf:JLM

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	67.8843	0.0508	1.604211			

M304S11GA

**

PK 2016/08/03

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

48.58998

M129545

31.99998

M129972

13.8

M134284

2.79

TPI

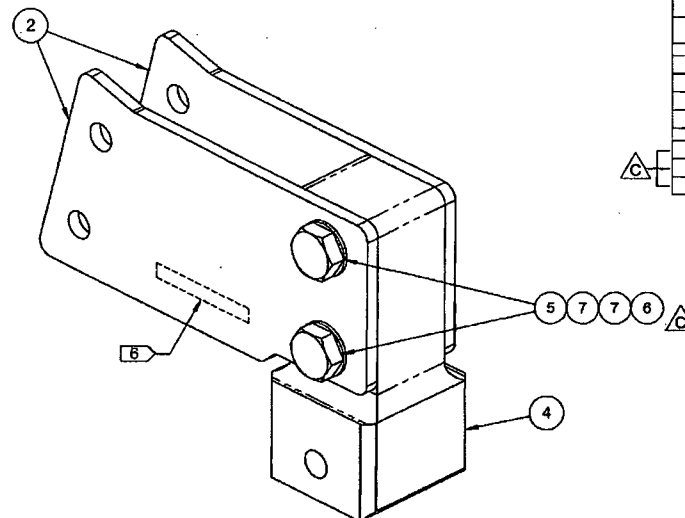
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M134604

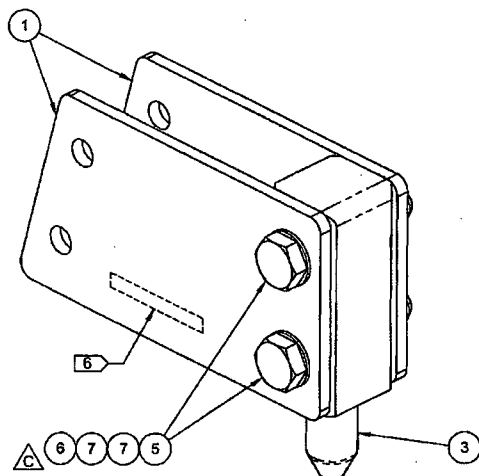
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M135355

2.6



D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

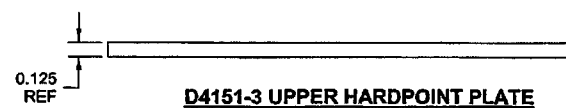
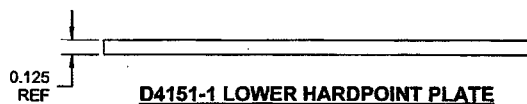
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

NOT A COPY
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 FOR IDENTIFICATION
 UNCONTROLLED COPY
 SUBJECT TO CURRENT
 WORK ORDER
 NO 14-6082 MJS
 16-05-09

RELEASED
 2011-01-18

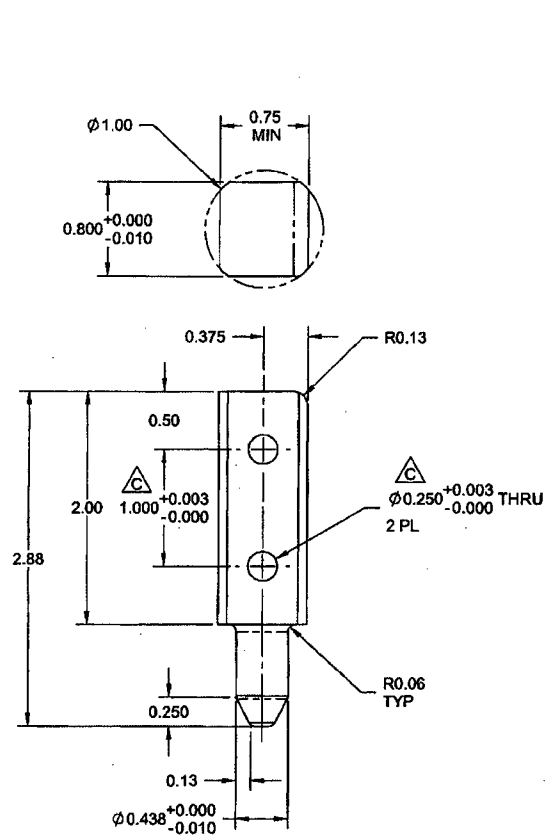
C	AN4 HARDWARE WAS AN3 (B8-1, C3-1 & D3-1); Ø0.252 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C3-3); Ø0.250 WAS Ø0.191 (C6-3, B4-3); 1.83 WAS 1.75 (C1-2), 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-797 DESIGN JOURNAL	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3811-1 (ZN B6-1 & D3-1); D4151-7 WAS D3811-3 (ZN C4-1 & D3-1) ITEMS #5, #6 & 7 REPLACE MS20615-4M20 (ZN C3-1, D3-1 & B8-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D550-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.08.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4151		REV. C	
TITLE BASKET FWD HARDPOINT		SCALE NTS	
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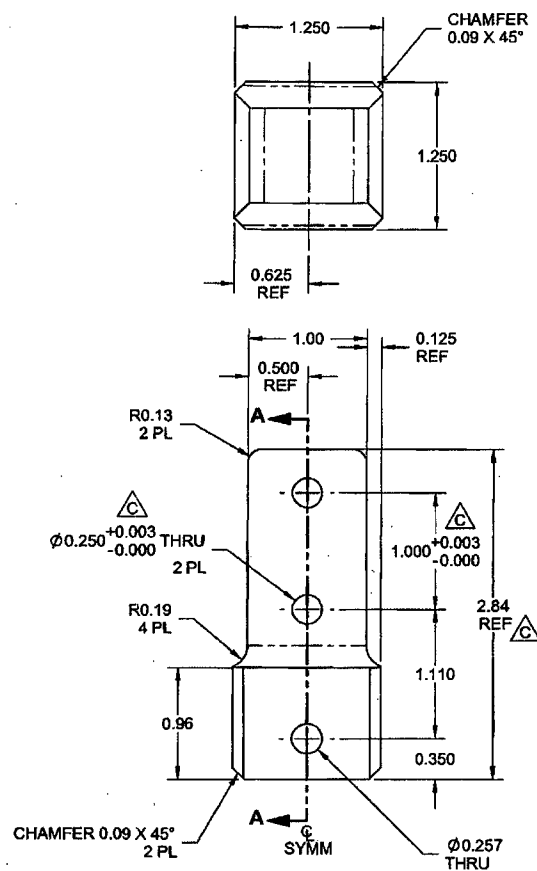
2) FINISH: NONE
REF. DART SPEC. M304STIGA OR M305STIGA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
7) WEIGHT:
- D4151-1 = 0.24 lbs
- D4151-3 = 0.23 lbs

RELEASED
2011-01-18
MD

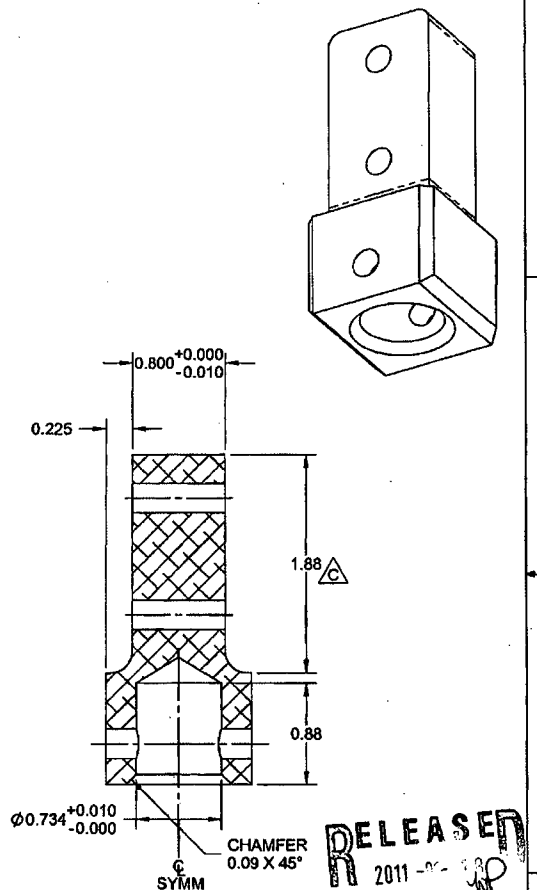
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4151	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET FWD HARDPOINT	NTS
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D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

NOTES:

- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
- 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JS			
CHECKED	Sc		DRAWING NO.	REV. C
MFG. APPR.	MS		D4151	SHEET 3 OF 3
APPROVED			TITLE	SCALE
DE APPR.	H		BASKET FWD HARDPOINT	NTS
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2011-10-10
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